

# EUROPEAN PATENT OFFICE

## Patent Abstracts of Japan

PUBLICATION NUMBER : 01064776  
 PUBLICATION DATE : 10-03-89

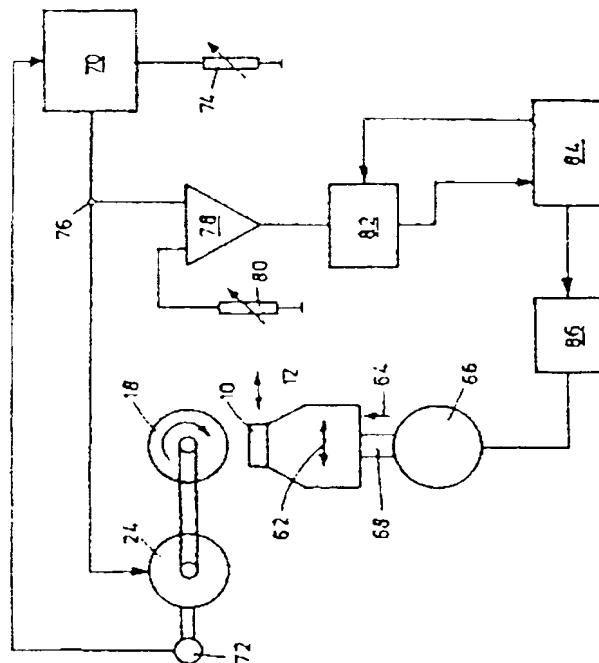
APPLICATION DATE : 26-08-88  
 APPLICATION NUMBER : 63210857

APPLICANT : LACH SPEZIAL WERKZEUGE GMBH;

INVENTOR : LACH HORST;

INT.CL. : B24B 49/16

TITLE : METHOD AND DEVICE FOR  
 CONTROLLING POSITIONING AND  
 CONTACT MOTIONS OF GRINDING  
 DISC



ABSTRACT : PURPOSE: To accurately feed after grinding by measuring the value changing corresponding to the friction moment applied to a grinding disc and stopping the touch-on motion at a point of time sequence of measurement values all reach a specified limiting value corresponding to the specified maximum value of friction moment.

CONSTITUTION: A current value of a driving motor 24 of a control tool 18 is taken at a branch terminal 76 and sent to a comparator 78 to be compared with a specific limiting value output from another potentiometer 80 therein. During operation, a sequence of measured current values and a controlled and preset limiting value are introduced to a current value storage device 82 and further introduced to an arithmetic device 84. in the arithmetic device 84, according to a control program controlled at every time, for the touch-on motion or the positioning motion, the current value or a difference from the limiting value is counted and synthesized in a regulated manner to output a control command according to the specific program from the arithmetic device 84 to a control circuit 86 of a step motor 66 for feeding a workpiece 10. Accordingly, after grinding, the workpiece 10 can be fed accurately at a correct time.

COPYRIGHT: (C)1989,JPO